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D2734

Job Sheet 185954



Part No: D2734

Job Qty: 36 ea

Part Name: Step End Plate



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/7/18

Job Tracking No:

Due Date: 11/28/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP: D 01.06.08 Removed Deburr EC IPP Rev:E 07-12-18 RevC as per dwg ECN1048 DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	36 pcs		11/28/18	0.00	0.50	Waterjet - Flow		21/11/18
120	QC	36 pcs		11/28/18	0.00	0.00	QC8		38
130	Small Fab	36 pcs		11/28/18	0.01	0.36	Small Fab-2		21/11/18
140	QC	36 pcs		11/28/18	0.00	0.00	QC5		38
150	Packaging	36 pcs		11/28/18	0.00	0.00	Packaging3		9-89
160	QC21-SA	36 Ea		11/28/18	0.00	0.00	QC21		9-89

Part Op 100 - 1-Cut as per Dwg D 2734
Descriptions: 130 - Form as per drawing D2734
150 - *** STOCK IN STEP CELL ***

DAS
21
9-89

DEC 12 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M5052H32S.063	5052-H32 .063 Sheet	2.2500 sf (.0625 ea)	100-Waterjet - Flow - 1	5076886 5082802

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M5052H32S.063	2	11	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	End Plate	2.900inches ± 0.030	2.930 2.870		
2	End Plate	3.040inches ± 0.030	3.070 3.010		
3	End Plate	0.063inches ± 0.010	0.073 0.053		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							



Container No: S128761



Part: D2734

Job No: 185954

Serial No/Batch: S128761

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 11/18/18

